




Work Order ID 59110







Wednesday, May 26, 2010 1:22:27 PM

Page 1

Item ID:	D2594-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Plug, 205 Skidtube				Stop	
Start Date:	5/26/2010	Start Qty:	200.00		Cust Item ID:	
Required Date:	6/4/2010	Req'd Qty:	200.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	10-5-26	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2594	Rev C								

100		0.00							
	Hardinge CNC LATHE SMALL								
Hardinge	Memo	0.00							205 
Hardinge CNC Lathe Small	1-Make as per Dwg D2594-1 and Folio FA262. 2-Break all sharp edges 0.010 max.								
				SA	10/06/11				
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
									
QC	Memo	0.00							205 
Quality Control									
				SA	10/06/11				
120	QC8- Inspect parts - second check	0.00							
									
QC	Memo	0.00							205 
Quality Control									
					28	10/06/14			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 59110

Wednesday, May 26, 2010 1:22:27 PM

Page 2

Item ID:	D2594-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Plug, 205 Skidtube				Stop	
Start Date:	5/26/2010	Start Qty:	200.00		Cust Item ID:	
Required Date:	6/4/2010	Req'd Qty:	200.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				205		62106-14	
140  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 1114841 Memo START TIME: 2:30pm 3:00pm FINISH TIME: 3:20pm OVEN TEMPERATURE:	0.00 0.00		ML 10/06/15		205			
150  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00						10 06 15 (205)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59110

Wednesday, May 26, 2010 1:22:27 PM

Page 3

Item ID: D2594-1

Accept

Revision ID:

Item Name: Plug, 205 Skidtube

Start Date: 5/26/2010 Start Qty: 200.00

Required Date: 6/4/2010 Req'd Qty: 200.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: FP-A

0.00

21 10/06/16

Packaging

Memo

0.00

205

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/16 MFMF
10-6-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 26, 2010 1:23:06 PM

Page 1

Work Order ID: 59110

Parent Item: D2594-1

Parent Item Name: Plug, 205 Skidtube

Comments: IPP D 02.08.22 Make in Cobra KJ
IPP E 06.12.11 ecn 836 EC

Start Date: 5/26/2010

Required Date: 6/4/2010

Start Qty: 200.00

Required Qty: 200.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.625		Purchased	No			110	f	103.5000	0.0521	10.96842			



6061-T6 Round Bar .625"



Location	Loc Qty	Loc Code
MAT	46	
114415	46	
MAT012	57.5	
112697	14.5	
113796	43	

12 R/ 5/26/10/06/11

10/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

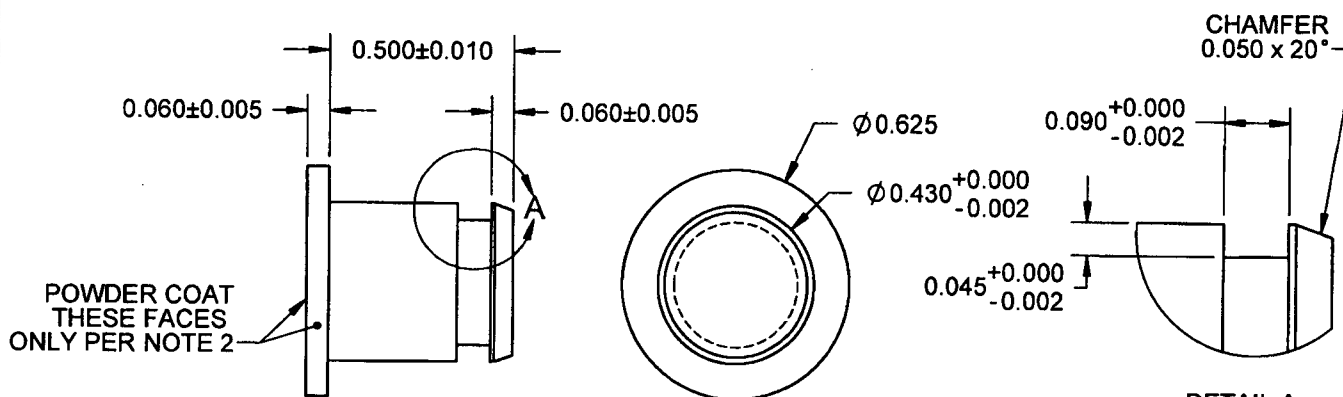
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DART

DESIGN <i>CH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>CH</i>	DRAWING NO. D2594	REV. C SHEET 1 OF 1
DATE 06.11.20		TITLE PLUG SCALE 2:1	
REV	DATE	DESCRIPTION	
A	96.09.16	NEW ISSUE	
B	97.03.15	ADD GROOVE AND O-RING	
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE	

RELEASED
06.11.28

**D2594-1 PLUG****D2594-1 PLUG NOTES:**

- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3 \triangle
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

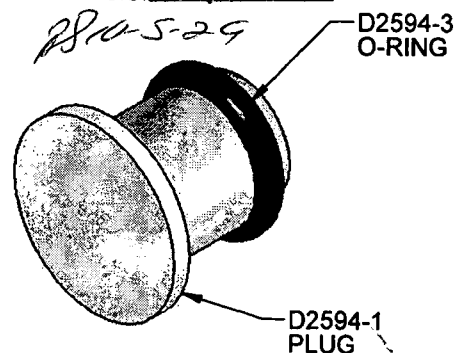
D2594-3 O-RING NOTES:

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011 \triangle

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *59110*

PARTS LIST:

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING

**D2594 PLUG ASSEMBLY**

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W/O:		WORK ORDER CHANGES					
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